

Date: Thursday, 2/9/2006 1:17:11 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BACK FRAME ASSEMBLY
<b>Job Number</b> : 25791	
<b>Estimate Number</b> : 11129	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3017041
<b>This Issue</b> : 2/9/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3017 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 2/25/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : [Signature] 06.02.09	
<b>Comment</b> : Est. A 01.09.19 New issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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**Comment:** Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)  
 4130 Tube .750 OD x.049W  
 Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall  
 Batch: M11642

AS 06/02/10

2.0	M4130NS049	4130 Sheet .049 wall
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**Comment:** Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s)  
 4130 Sheet .049 wall  
 Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)  
 Batch: M16443

AS 06/02/10

3.0	D30177	Lug
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**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Lug  
 Pick:  
 Qty Part Number Description Batch  
 3 D3017-7 Lug B22411

AS 06/02/10

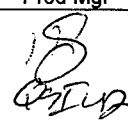
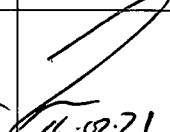
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 1-Cut all tubes as per Dwg D3017  
 2-Cut end caps as per Dwg D3017  
 3-Weld as per Dwg D3017 using Welding Jig Dt8598  
 A/R Steel Rod Batch: M9430

AS 06/02/13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/02/21	1	<del>Install D3023-1 to 3017-041</del> 40 MS 20600 AD 4W 2 Rivet M4747 6 MS 20600 AD 4W 3 Rivet M18071 Back Panel D3023-1 B25797 Inspect QCS - 06.02.21	SB	06/02/21	1	 06.02.21	 16.02.21

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/9/2006 1:17:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 25791

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill D3017-041 Using DT8621

5-Deburr

AA 06/02/13

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-02-13

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 02 21

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/02/28

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB 06/02/28

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PD 06/02/28

Job Completion



U 06-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

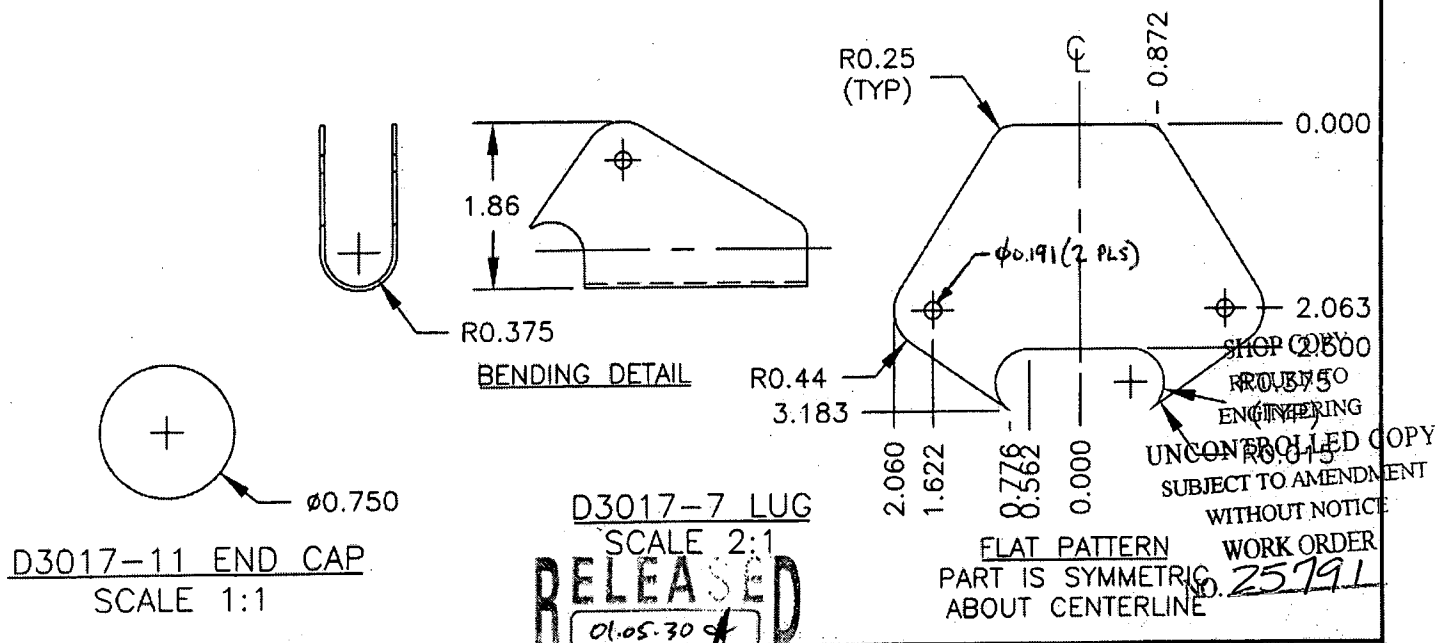


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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